

Blue

Work Order ID 129146

129146

Page 1

Item ID: D2939-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: 206 Saddle Left Side
Start Date: 1/29/15 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 2/27/15 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2939	Rev C								

100	HAAS CNC VERTICAL MACHINING #1	0.00				4	0		
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per								

15-03-25

110	CONVENTIONAL MILLING MACHINE	0.00				4	0		
110									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

15-03-25

120	QC1- Inspect dimensions to dimension sheet	0.00				4	0		
120									
QC	Memo	0.00							
Quality Control									

15-03-25

PTO

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>129146</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2939-1</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4810</u>		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15/3/30	100	4	Dim 0.235- 0.240 is 0.225 due to buffing, in area of control ridge only. P.C operator	DAS 12 9-89 15/3/30 P-15-03-30	Acceptable. Affected area is small and all transitions are smooth.	DAS 12 9-89 15/3/31 P-15-03-30	15/03/31	DAS 9 9-89 15-04-01
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☒ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

January-29-15 10:45:55 AM

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						4	0		DAS
QC	Memo	0.00		15/04/01					08
Quality Control									9-89
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						4		15-4-2	
HandFinish	Memo	0.00							
Hand Finishing									

[Handwritten signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 41 9-89
155		0.00				4			
155									
SprayPaint	Memo	0.00							
Spray Painting	PRIME B <u>131846</u>								15-4-6
	DELFLEET BLUE B <u>128955</u>								
	DELFLEET CLEAR B <u>129058</u>								
	PRIME:								
	Start time: <u>100</u>								
	Finish Time: <u>130</u>								
	PAINT:								
	Start time: <u>300</u>								
	Finish Time: <u>400</u>								
165	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
165									
QC	Memo	0.00							
Quality Control									

APR 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 4

January-29-15 10:45:55 AM

Reference:

Stop ***NR2***

APR 09 2015

180	QC21- Final Inspection - Work Order Release	0.00
180		
QC	Memo	0.00
Quality Control		

MLJ 15-04-09

MS-4-C

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Picklist Print

January-29-15 10:45:55 AM

Page 1

Work Order ID: 129146

129146

Parent Item: D2939-1

D2939-1

Parent Item Name: 206 Saddle Left Side

Start Date: 1/29/15

Required Date: 2/27/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	53.0000	1	4			

D6101-001

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

13

114353

5

124413

8

MAT045

40

115128

10

122672

10

125829

20

15-03-25

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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DART AEROSPACE LTD	Work Order:	129146
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

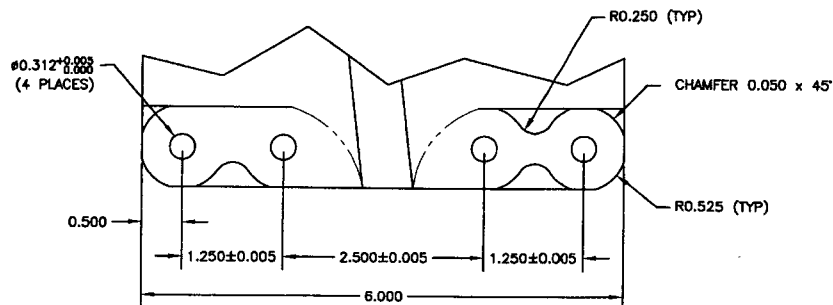
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.120	.119	.119		
B	0.100	0.140		.120	.120	.119	.120		
C	0.100	0.140		.116	.118	.120	.118		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.545	.550	.550	.552		
P	0.490	0.510		.503	.502	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.739	2.741	2.742	2.741		
S	0.240	0.270		.242	.251	.251	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.259	1.260		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.574	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	P 15-03-25
Date:	

Audited by:	B.A.	DAS
Date:	15/04/01	08
		0-80

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

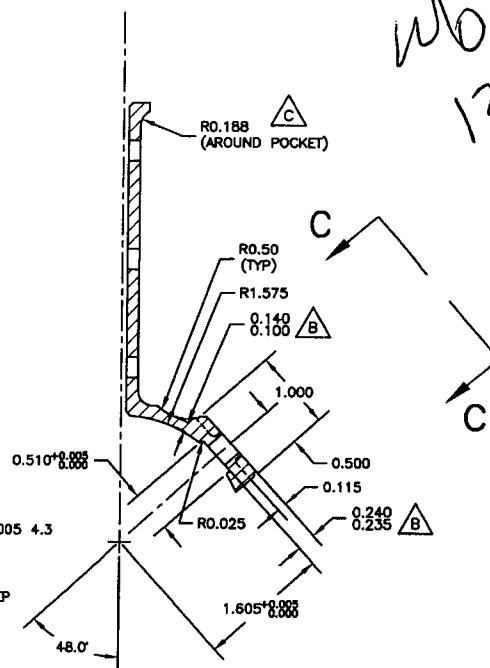


VIEW C-C

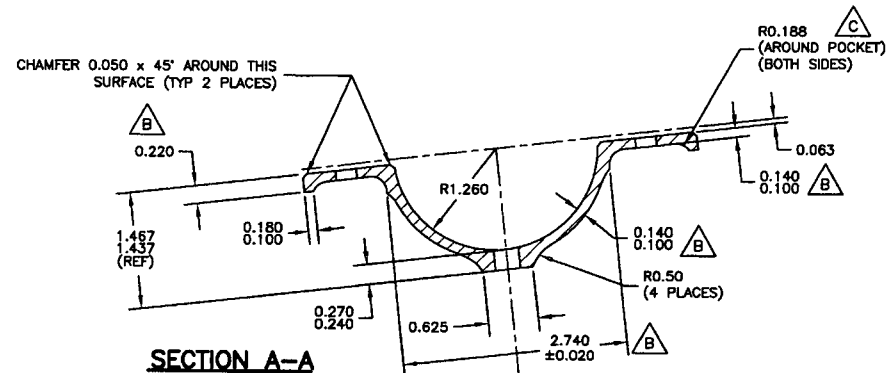
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

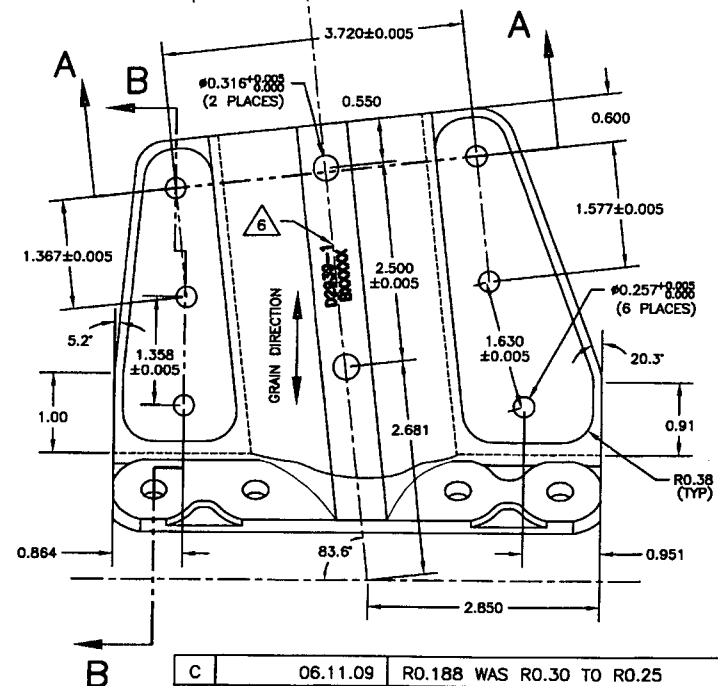
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DART DART AEROSPACE USA, INC.
DATE	06.11.09	SADDLE INSIDE

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AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DRAWING NO.
D2939

REV. C
SHEET 1 OF 1

SCALE
2:3



Part Number: D2939-1	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2939	Work Order: 129146

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
D Distance YZ	0.2200	0.0100 -0.0100	0.2174	0.2188	0.2178	0.2187	
E Distance XY	1.2500	0.0050 -0.0050	1.2503	1.2501	1.2501	1.2507	
F Distance XY	1.2500	0.0050 -0.0050	1.2492	1.2486	1.2491	1.2497	
G Distance XY	2.5000	0.0050 -0.0050	2.5003	2.5002	2.5000	2.4996	
I Distance XY	1.5770	0.0050 -0.0050	1.5771	1.5782	1.5778	1.5764	
J Distance XY	2.5000	0.0050 -0.0050	2.4997	2.5003	2.5000	2.4996	
K Diameter	0.2570	0.0050 -0.0010	0.2585	0.2586	0.2583	0.2588	
L Diameter	0.3120	0.0050 -0.0010	0.3132	0.3130	0.3130	0.3135	
N Distance YZ	0.1200	0.0200 -0.0200	0.1188	0.1199	0.1191	0.1201	
O Distance XY	0.5500	0.0100 -0.0100	0.5524	0.5451	0.5499	0.5505	
P Distance XY	0.5000	0.0100 -0.0100	0.4991	0.5018	0.4982	0.4998	
Q Distance XY	3.7200	0.0050 -0.0050	3.7191	3.7194	3.7193	3.7192	
R Distance XY	2.7400	0.0200 -0.0200	2.7435	2.7422	2.7441	2.7437	
U Distance XY	1.6300	0.0050 -0.0050	1.6298	1.6291	1.6295	1.6307	
V Distance XY	1.3670	0.0050 -0.0050	1.3675	1.3677	1.3672	1.3675	
W Diameter	0.3160	0.0050 -0.0010	0.3161	0.3167	0.3161	0.3161	
Z Radius	0.1880	0.0100 -0.0100	0.1950	0.1897	0.1945	0.1949	

Measured by:
Mathieu Lamarche

Date:
2015-3-29

Audited by:

DAS
08
9-99

Date:

15/04/01